

Work Order ID 59301

Monday, May 31, 2010 1:01:54 PM

Page 1

Item ID: D350-591-311

Accept

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/31/2010 Start Qty: 10.00

Required Date: 6/14/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date: 10-5-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M112860

3-Grind End Plate flush

M114242

10-06-08 10 P

for BG 10/06/15

Sub 6/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	2E10/06/08	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81066605		(10) 44			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		10.06.08		10			

Dart Aerospace Ltd

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

M-L

10/06/08

10X

180



Large Fab

Large Fab

Large Fab

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M112360

6-Grind End Plate flush

7-Install last rivet as per Dwg.

0.00

0.00

10

10.06.10

Dart Aerospace Ltd

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(10) PD 10.06.11

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

(X10)
LH

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JOHN PD 10-6-11

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1114841 Memo START TIME: 10:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:00PM	0.00 0.00		⇒ 4/ 10/06/4		X 10	Ø		
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 114432 Memo	0.00 0.00				10	16K 10-6-14		
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				ml	10	06 14 (10)	

Dart Aerospace Ltd

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

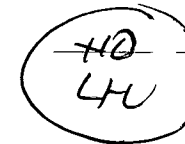
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
260	QC4- 100% Inspect kits for completeness	0.00							
	QC								
	Memo	0.00							
	Quality Control								
270		0.00							
	Packaging								
	Memo	0.00							
	Packaging								
	Packaging								
	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>B</u>								

10-6-16 SP 100

8/10/06/17



10/6/16 (10)

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21

mr
10-6-18

W/O:		WORK ORDER CHANGES					
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Work Order ID: 59301

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH









Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Date: 5/31/2010

Required Date: 6/14/2010

Start Qty: 10.00

Required Qty: 10.00

D3067-1	Manufactured	No	110	Each	75.0000	1	10	
								
End Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	75				
			57926	75			10	
D3219-1	Manufactured	No	110	Each	65.0000	2	20	
								
Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	65				
			58550	65			20	
D3272-1	Manufactured	No	110	Each	4.0000	1	10	
								
Step								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	4			10	
			58809	4				
D3065-041	Manufactured	No	180	Each	52.0000	1	10	
								
Step Leg Assembly Hi								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	52				
			58160	12			3	
			58536	40			7	

6

10.06.07

10

10.06.07

20

10.06.07

10

10.06.10

3

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 5/31/2010

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 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

D3066-1	Manufactured	No	180	Each	153.0000	2	20			<u>10-06-10</u>
Spacer										
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			WA	153						
			57920	53			<u>20</u>			
			58540	100						
D3067-1	Manufactured	No	180	Each	75.0000	1	10			<u>10-06-10</u>
End Plate										
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			WA	75			<u>10</u>			
			57926	75						
MS20600-AD4W4	Purchased	No	180	Each	567.0000	16	160			<u>10-06-10</u>
Rivets										
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			ST309	100						
			114761	100			<u>66</u>			
			ST321	467						
			113368	62						
			114181	105						
			114718	300			<u>94</u>			

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Start Date: 5/31/2010

Required Date: 6/14/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 101.0000 2 20
S# Bolt 10-6-17 S

Location	Loc Qty	Loc Code
ST353	101	
112314	1	
114382	50	20
114523	20	
114784	30	

AN4-13A Purchased No 250 Each 401.0000 8 80
S# Bolt 10-6-17 S

Location	Loc Qty	Loc Code
ST351	101	
114523	101	
ST357	300	
114752	300	80

AN5-36A Purchased No 250 Each 137.0000 2 20
S# Bolt 10-6-16 S

Location	Loc Qty	Loc Code
ST341	137	
114292	87	20
114784	50	

AN960JD10 NAS1149D0363J Purchased No 250 Each 0.0000 4 40
S# Washer 1114884 10-6-16 S 100

W/O:		WORK ORDER CHANGES					
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Start Date: 5/31/2010

Required Date: 6/14/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD416	NAS1149D0463J	Purchased	No	250	Each	0.0000	16	160
Washer								
AN960JD516	NAS1149D0563J	Purchased	No	250	Each	0.0000	4	40
Washer								
D2230-3		Manufactured	No	250	Each	73.0000	4	40
Lug								

Location Loc Qty Loc Code

ST476 73
57827 73

D2618		Manufactured	No	250	Each	73.0000	2	20
Bushing								

Location Loc Qty Loc Code

ST020 73
56892 1
57829 72

D2856-400		Manufactured	No	250	f	269.1088	0.6	6
Abraison Strip								

Location Loc Qty Loc Code

ST403 269.1088
50593 62.0568
56626 207.052

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Shop Packet Print

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Start Date: 5/31/2010

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Start Qty: 10.00

Required Qty: 10.00

S #10	D3235-1	Manufactured	No	250	Each	3.0000	2	20	58717 10-6-16
									
	Mounting Lug								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST471		3					
		57921		3					
S #10	D3278-041	Manufactured	No	250	Each	30.0000	1	10	10-6-16
									
	Support Assembly								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST471		30					
		57952		30					
S #10	MS21042L3	Purchased	No	250	Each	3,655.000	2	20	10-6-16 20
									
	Nut								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST300		3655					
		113537		20					
		113644		135					
		114523		1000					
		114718		500					
		114784		2000					

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Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

4,458.000

8

80



70 Nut



10-6-16 SL

Location

Loc Qty

Loc Code

ST139

2

111827

2

ST300

4456

113422

76

114523

1372

114718

1000

114784

2000

9063

8

MS21042L5

Purchased

No

250

Each

497.0000

2

20



8 Nut



10-6-16 SL (100)

Location

Loc Qty

Loc Code

ST300

497

113537

3

114437

94

114449

400

20

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DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JB</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *JB*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59301

10-5-31

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

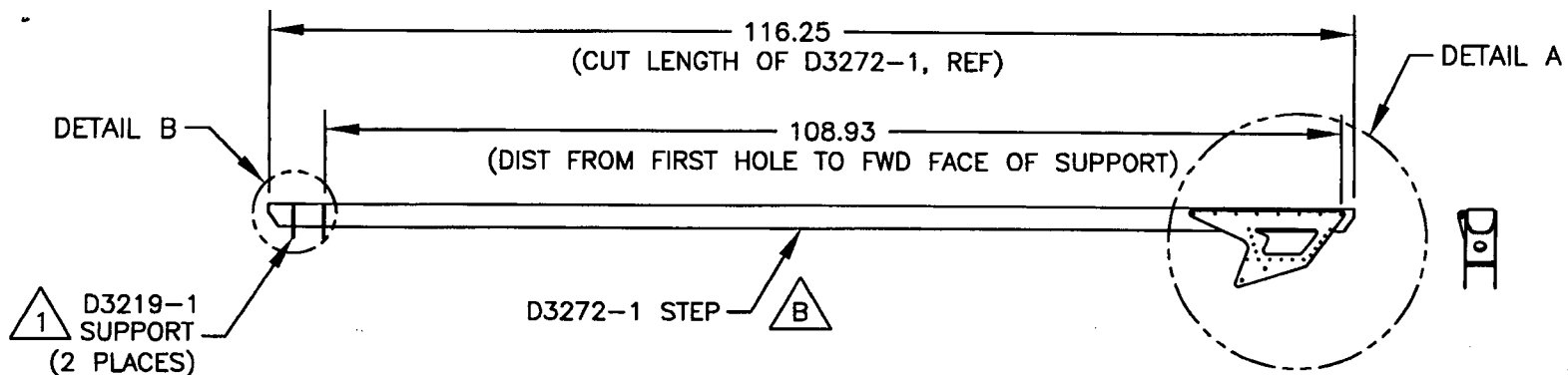
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

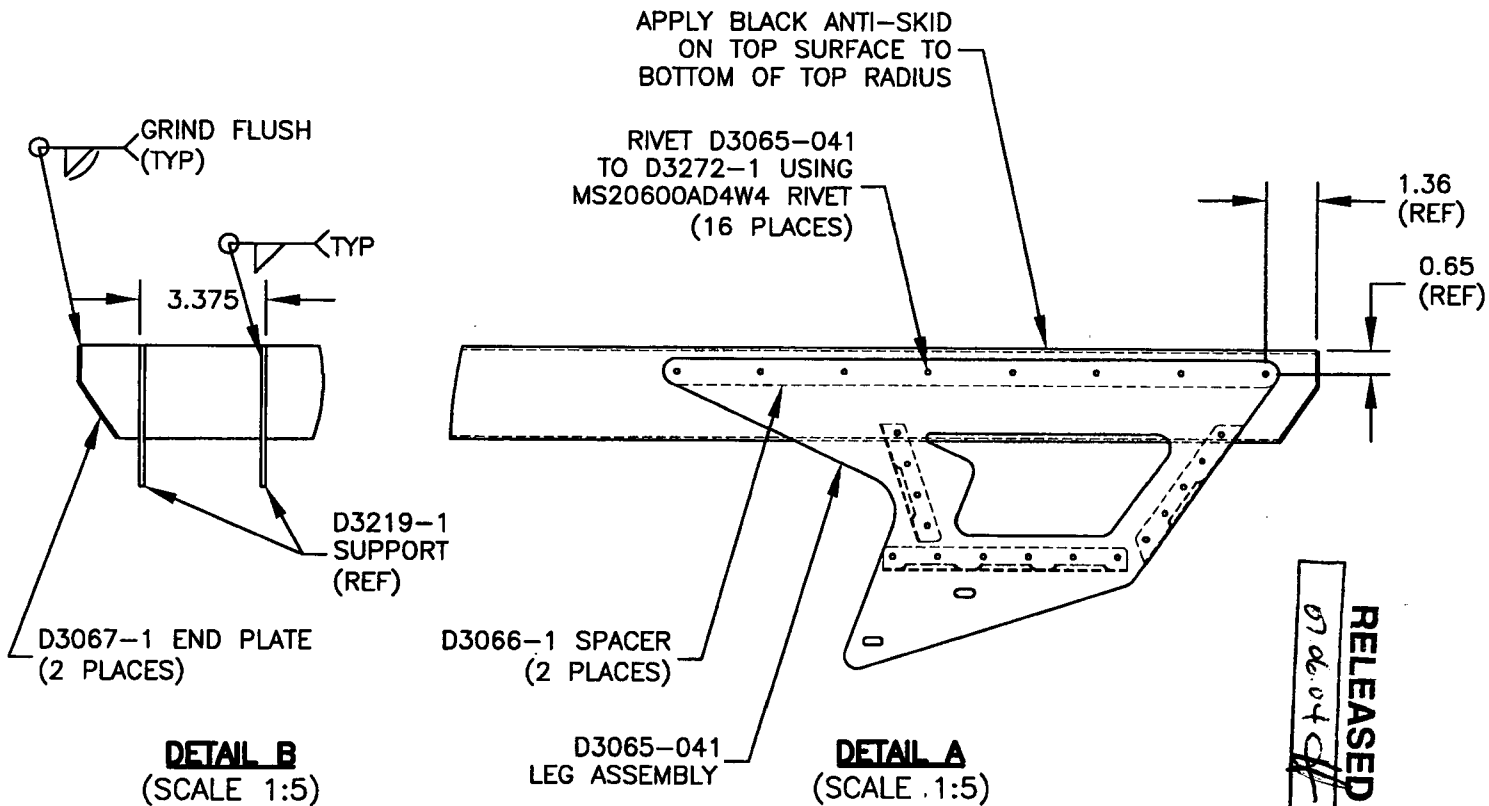
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	

w/o 59301

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

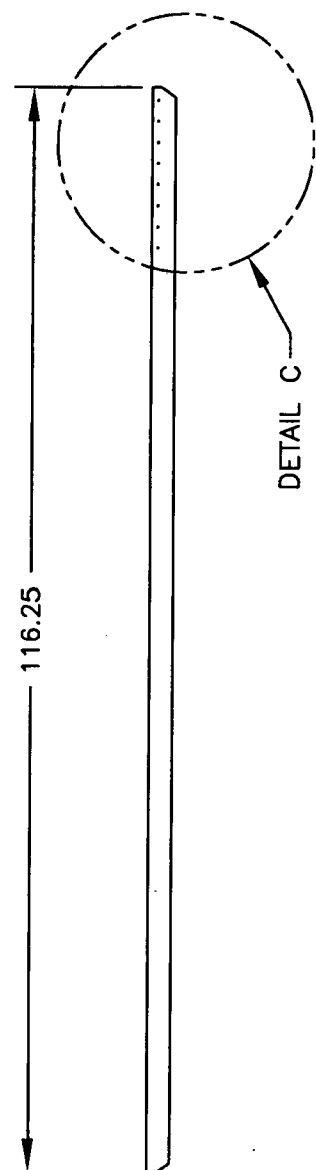
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

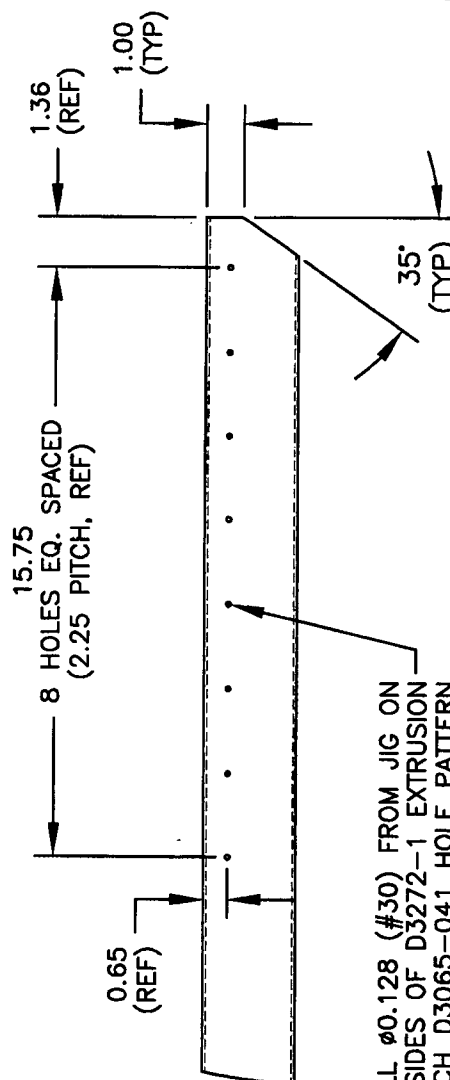
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

146 39301

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries